Work Order ID 86672

July-06-12 11:20:45 AM

86672

Item ID: D3407-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Tow Ring

Start Date: 7/06/12 **Start Qty:** 40.00 ~~*40*~~ *40* 25 **Cust Item ID:**
Required Date: 8/10/12 **Req'd Qty:** 40.00 **Customer:**
Reference:

Approvals: **Process Plan:** N **Date:** 12-07-16 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3407	Rev E								
100		0.00							
100	Large Fab					25			12-07-16
Large Fab	**Memo**	0.00							
Large Fab	Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004 A/R TIG174 ROD Batch: M101972								JBL
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									QC 12.7.16
QC	**Memo**	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120						counts +25			
QC	**Memo**	0.00							
Quality Control		DAS 16 2-53 12/07/16							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3407-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Tow Ring

Start Date: 7/06/12 **Start Qty:** 40.00 *40*
Required Date: 8/10/12 **Req'd Qty:** 40.00 *40*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00				25X	ϕ		12/07/17
130									
Powdercoat	**Memo**	0.00							
Powder Coating	**Mask Threaded Section** 8:00 START TIME: _____ OVEN TEMPERATURE: 400°F FINISH TIME: 8:30								
WM21841									
140	QC3- Inspect Part Finish	0.00				25	ϕ		12-7-17
140									
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location ST 463	0.00				25x			12-7-17
150									
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3407-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Tow Ring

Start Date: 7/06/12 **Start Qty:** 40.00 *40*
Required Date: 8/10/12 **Req'd Qty:** 40.00 *40*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					12/7/19		
160									
QC	**Memo**	0.00							
Quality Control									

MF
12-07-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July-06-12 11:20:45 AM

Work Order ID: 86672

Parent Item: D3407-041 **Start Date:** 7/06/12 **Required Date:** 8/10/12

Parent Item Name: Tow Ring **Start Qty:** 40.00 **Required Qty:** 40.00

Comments: IPP Rev:A05.10.14New issueKJ/EC
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-1 Stem		Manufactured	No			100	Each	61.0000	1	40			

Location	Loc Qty	Loc Code
WA	61	
– 83436	31	
– 84946	30	

12-07-13 JBL

42
23

D3407-5 Ring		Manufactured	No			100	Each	0.0000	1	40			

85424

25

12-07-13 JBL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

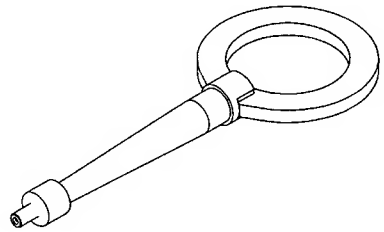
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

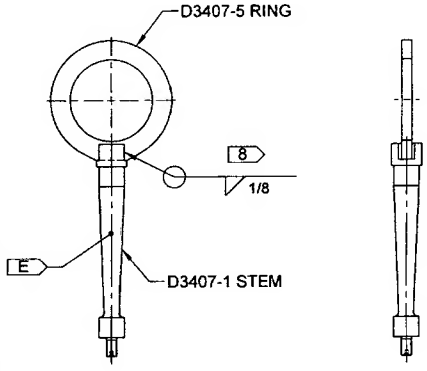
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

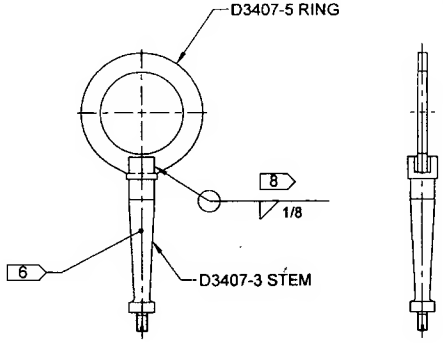
NOTE: Date & initial all entries

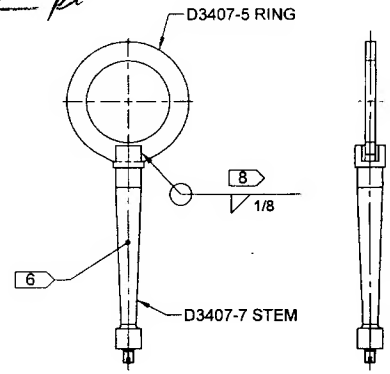
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 96022 pl12074









RELEASED
08-08-23 MM

D3407-041 TOW RING

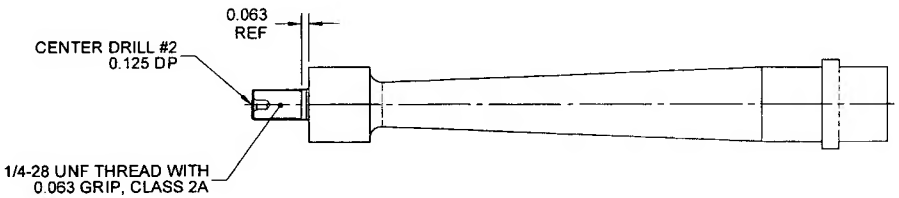
D3407-043 TOW RING

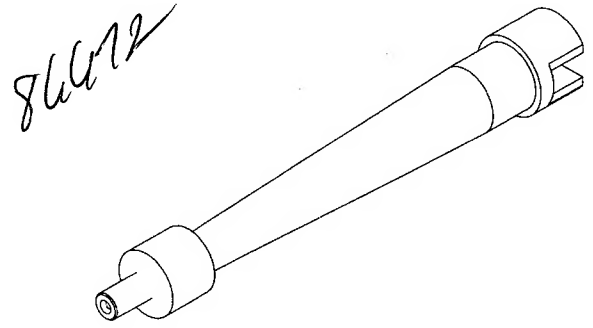
D3407-045 TOW RING E

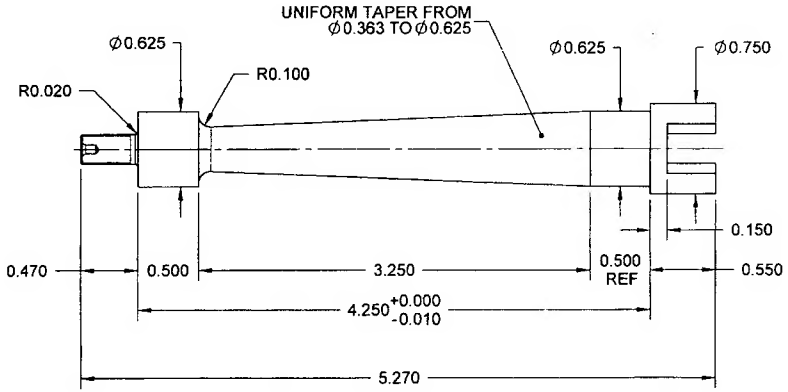
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER E
7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

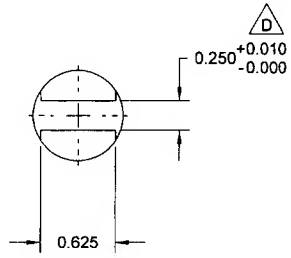
REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16

DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3407 REV. E
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE TOW RING SCALE NTS
DE APPR.		
DATE	08.07.23	







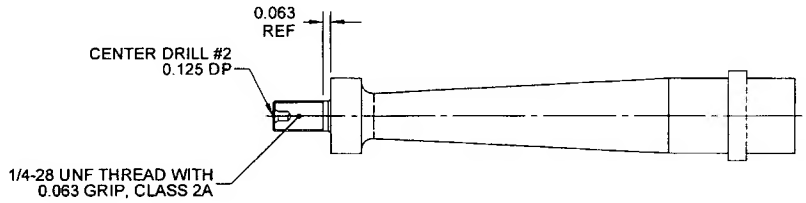


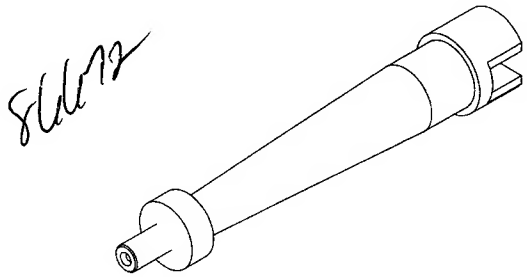
D3407-1 STEM

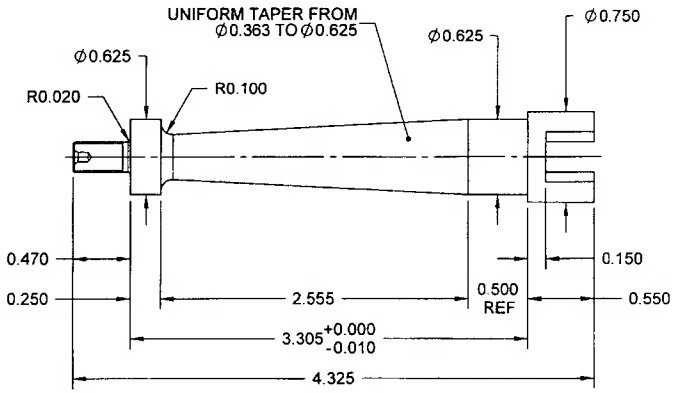
RELEASED
05.05.23

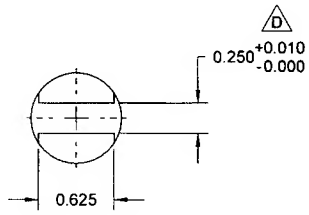
NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3407 REV. E
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE TOW RING SCALE NTS
DE APPR.		
DATE 08.07.23		







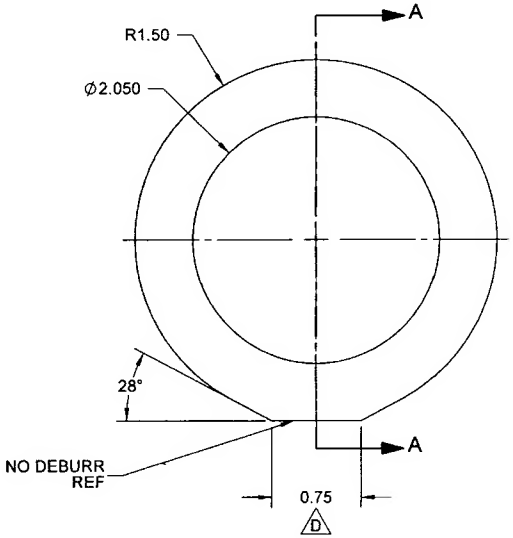


D3407-3 STEM

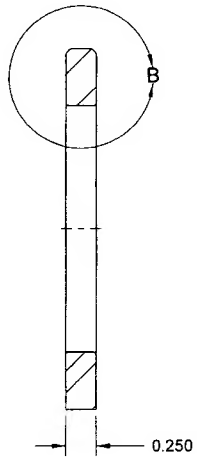
RELEASED
08-08-23 NG

NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

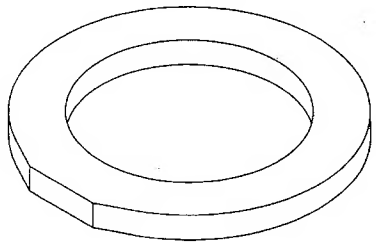
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3407 REV. E
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE TOW RING SCALE NTS
DE APPR.		
DATE 08.07.23		

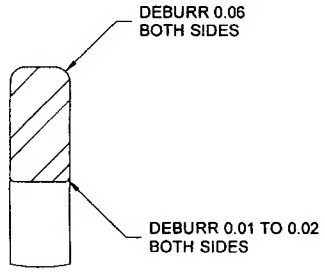


D3407-5 RING



SECTION A-A



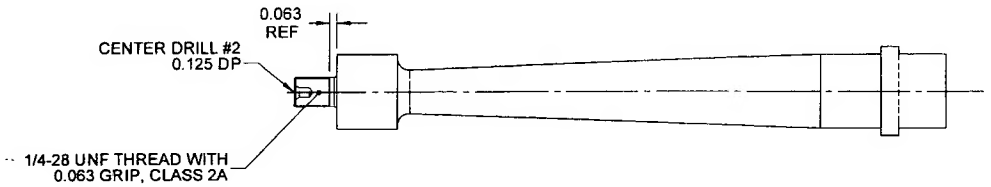


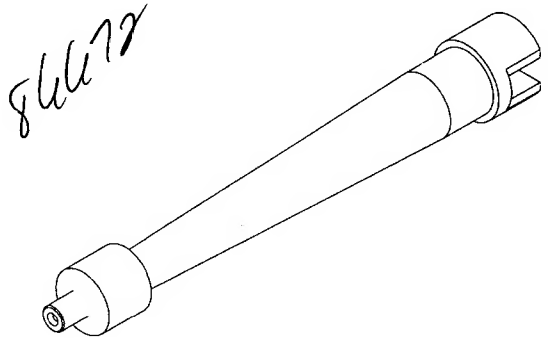
DETAIL B
SCALE 2X

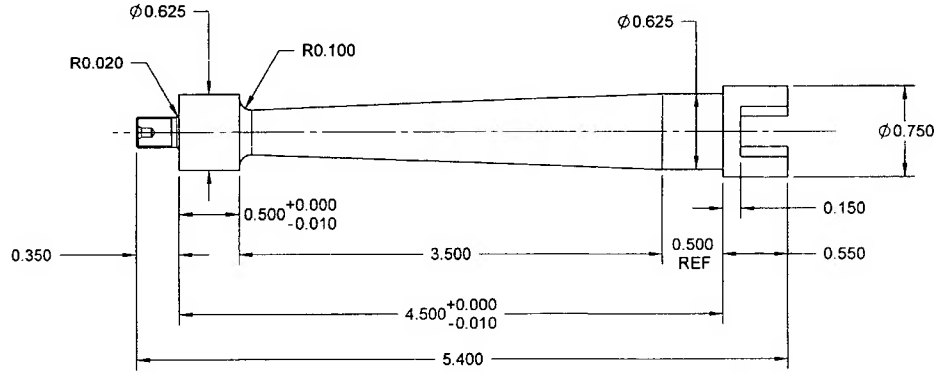
RELEASED
08.04.2023

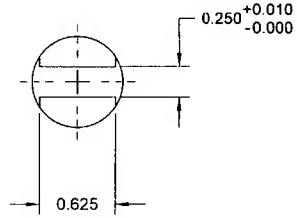
NOTES:
1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

DESIGN	QP	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	QP	
CHECKED		DRAWING NO. D3407 — REV. E — SHEET 4 OF 5
MFG. APPR.		
APPROVED		TITLE: TOW RING — SCALE: NTS
DE APPR.		
DATE 08.07.23		









△E **D3407-7 STEM**

RELEASED
04.04.01 MP

NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

DESIGN	AJS	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3407 REV. E
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE TOW RING SCALE NTS
DE APPR.		
DATE	08.07.23	